

6/20/2019

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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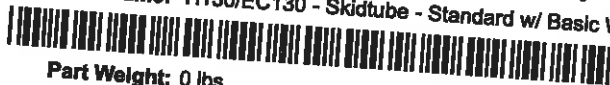
D130-1048-011
Job Sheet 196753



Part No: D130-1048-011

Job Qty: 1 pcs

Part Name: H130/EC130 - Skidtube - Standard w/ Basic Wearplates - LH



Part Weight: 0 lbs

Job Created: 6/20/19

Due Date: 7/12/19

Type: SOLD

Status: New

Job Tracking No:

Priority: Medium

Created By: Marie Lajeunesse

Description:

Note: DWG D130-1048-011 REV.C/ IIN-D130-1048 REV.C IPP REV:A DP verify DD 17.07.09

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Handfinish - 4 - Assembly	1 pcs		7/12/19	0.00	0.50	Handfinish - 4 - 1		JL 19-8-22
							Handfinish - 4 - 10		
							Handfinish - 4 - 11		
							Handfinish - 4 - 12		
							Handfinish - 4 - 13		
							Handfinish - 4 - 14		
							Handfinish - 4 - 15		
							Handfinish - 4 - 2		
							Handfinish - 4 - 3		
							Handfinish - 4 - 4		
							Handfinish - 4 - 5		
							Handfinish - 4 - 6		
							Handfinish - 4 - 7		
							Handfinish - 4 - 8		
							Handfinish - 4 - 9		
							QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
120	QC 5	1 pcs		7/12/19	0.00	0.00			



Container No: S207951



Part: D130-1048-011

Job No: 196753

Serial No/Batch: S207951

Revision: C/C

Inspector:

Exp Date:

Instructions: TC STC SH19-4 Issue 1, FAA STC SR04320N

1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

6/20/2019

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

DAS
40
9-89

AUG 26 2019

130 Packaging 1-1 - Pick Kit - B4B 1 pcs

7/12/19

0.00 0.00

QC 5 - 40

Packaging 1 - 1 - B4B

Packaging 1 - 2 - B4B

Packaging 1 - 3 - B4B

Packaging 1 - 4 - B4B

Packaging 1 - 5 - B4B

Packaging 1 - 6 - B4B

Packaging 1 - 7 - B4B

Packaging 1 - 8 - B4B

Packaging 1 - 9 - B4B

Packaging 1 - 10 - B4B

Packaging 1 - 11 - B4B

Packaging 1 - 12 - B4B

Packaging 1 - 13 - B4B

Packaging 1 - 14 - B4B

Packaging 1 - 15 - B4B

Packaging 1 - 16 - B4B

Packaging 1 - 17 - B4B

Packaging 1 - 18 - B4B

Packaging 1 - 19 - B4B

Packaging 1 - 20 - B4B

Packaging 1 - 21 - B4B

Packaging 1 - 22 - B4B

Packaging 1 - 23 - B4B

Packaging 1 - 24 - B4B

Packaging 1 - 25 - B4B

Packaging 1 - 26 - B4B

Packaging 1 - 27 - B4B

Packaging 1 - 28 - B4B

Packaging 1 - 29 - B4B

Packaging 1 - 30 - B4B

Packaging 1 - 31 - B4B

Packaging 1 - 32 - B4B

Packaging 1 - 33 - B4B

Packaging 1 - 34 - B4B

Packaging 1 - 35 - B4B

Packaging 1 - 36 - B4B

135 QC 4

1 pcs

7/12/19

0.00 0.00

QC 4 - 28

QC 4 - 58

QC 4 - 69

QC 4 - 9

QC 4 - 46

QC 4 - 68

QC 4 - 72

QC 4 - 74

QC 4 - 75

140 Packaging 3-1 - Stock - B4B 1 pcs

7/12/19

0.00 0.00

Packaging 3 - 1 - B4B

Packaging 3 - 2 - B4B

Packaging 3 - 3 - B4B

Packaging 3 - 4 - B4B

Packaging 3 - 5 - B4B

Packaging 3 - 6 - B4B

Packaging 3 - 7 - B4B

Packaging 3 - 8 - B4B

Packaging 3 - 9 - B4B

Packaging 3 - 10 - B4B

Packaging 3 - 11 - B4B

Packaging 3 - 12 - B4B

Packaging 3 - 13 - B4B

MWB

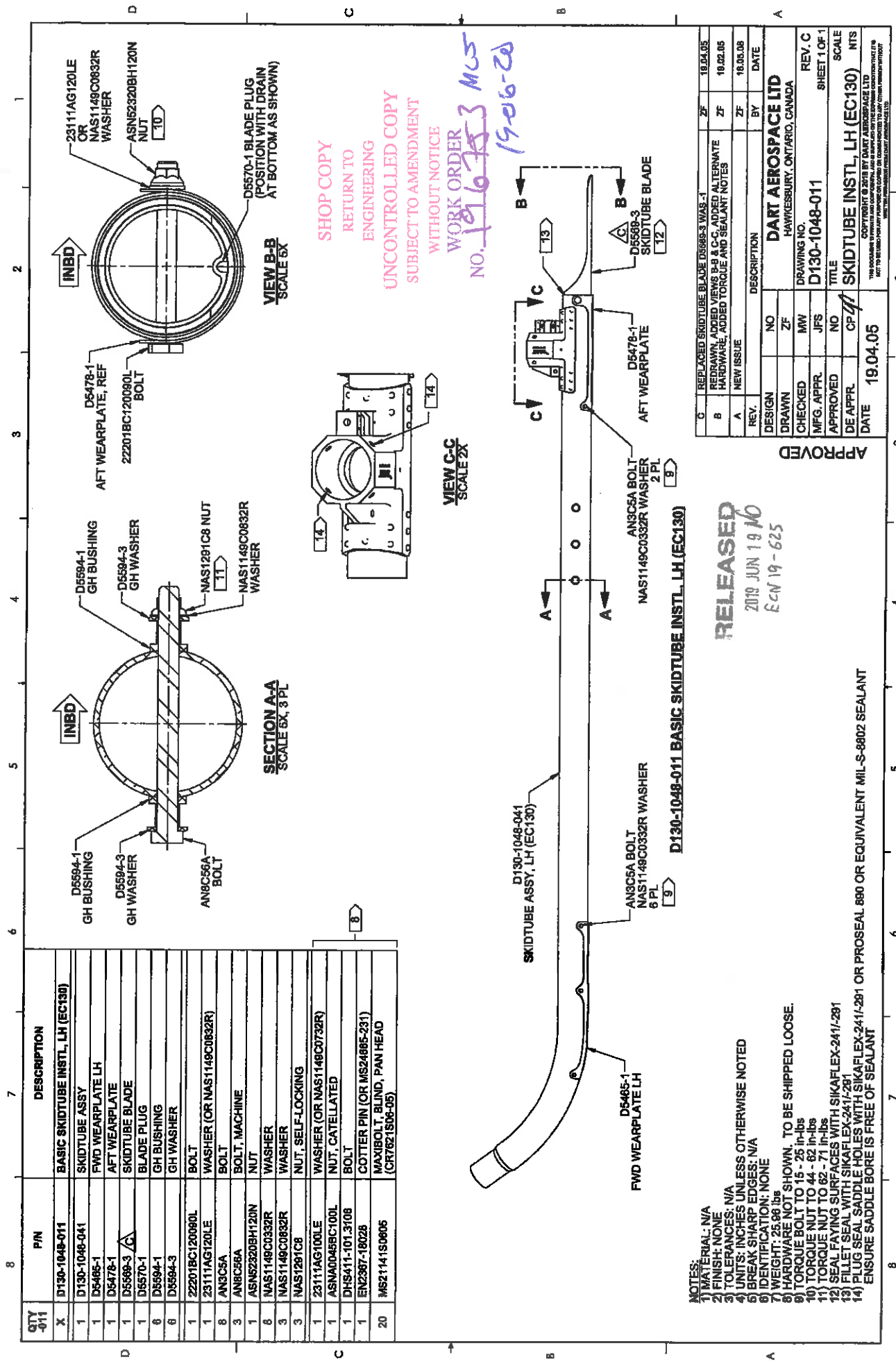
9/5/2019

				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
155 DC - 1 - B4B	1 pcs	7/12/19	0.00 0.00	DC - 1 - B4B	DAS 21 SEP 05 2019
				DC - 2 - B4B	DAS 21 SEP 05 2019
165 QC 21 - SA	1 pcs	7/12/19	0.00 0.00	QC 21 - SA - 21	DAS 21 SEP 05 2019
				QC 21 - SA - 70	DAS 21 SEP 05 2019
				QC 21 - SA - 53	DAS 21 SEP 05 2019

Part Op 110 - ASSEMBLE AS PER DWG SEE DWG NOTES 9) TORQUE BOLT TO 15 - 25 in-lbs 10) TORQUE NUT TO 44 - 62
 Descriptions: in-lbs 11) TORQUE NUT TO 62 - 71 in-lbs 12) SEAL FAYING SURFACES WITH SIKAFLEX-241/-291 13) FILLET SEAL
 WITH SIKAFLEX-241/-291 14) PLUG SEAL SADDLE HOLES WITH SIKAFLEX-241/-291 SEALANT ENSURE SADDLE
 BORE IS FREE OF SEALANT
 120 - QC5- Inspect part completeness to step on W/O
 130 - Pick Kit - BAG AND ID HARDWARE.
 135 - QC4- 100% Inspect kits for completeness
 140 - Identify and pack for shipping as per PPP D130-1048-011 Location: _____ PPP Rev: _____
 155 - Document Control - Photocopy blue file and create labels as per PPP D130-1048-011 chg 001
 165 - QC21- Final Inspection - Work Order Release

Job BOM					011553
Part / Item	Component Name	Quantity	Operation	Container	
22201BC120090L	Bolt 5578	1 Ea (1 ea)	110-Handfinish - 4 - Assembly	5147858	
23111AG120LE	Washer	1 Ea (1 ea)	110-Handfinish - 4 - Assembly	5135792	
AN8C56A	Bolt	3 Ea (3 ea)	110-Handfinish - 4 - Assembly	5197957	
ASN52320BH120N	Nut	1 Ea (1 ea)	110-Handfinish - 4 - Assembly	5198683	
D130-1048-041	H130/EC130 - Replacement Skidtube - Standard - LH	1 pcs (1 ea)	110-Handfinish - 4 - Assembly	5203285	
D130-1048-051	H130/EC130 - Wearplates - DART & OEM Replacement - Basic - LH	1 pcs (1 ea)	110-Handfinish - 4 - Assembly	5202337	
D5599-3	Replacement Blade - Basic Aluminum	1 pcs (1 ea)	110-Handfinish - 4 - Assembly	5194976	
D5570-1	Blade Plug	1 pcs (1 ea)	110-Handfinish - 4 - Assembly	5102647	
D5594-1	GH Bushing	6 pcs (6 ea)	110-Handfinish - 4 - Assembly	5193419	
D5594-3	GH Washer	6 pcs (6 ea)	110-Handfinish - 4 - Assembly	5196648	
NAS1149C0832R	Washer (AN960C818L)	3 Ea (3 ea)	110-Handfinish - 4 - Assembly	5076017	
NAS1291C8	Nut, Self-Locking	3 Ea (3 ea)	110-Handfinish - 4 - Assembly	5112904	
23111AG100LE	Washer	1 Ea (1 ea)	130-Packaging 1-1 - Pick Kit - B4B	5156062	
ASNA0045BC100L	Nut, Castellated	1 Ea (1 ea)	130-Packaging 1-1 - Pick Kit - B4B	5109874	
DHS411-101.3106	Metric Hex Head Aerospace Bolt	1 Ea (1 ea)	130-Packaging 1-1 - Pick Kit - B4B	5198684	
MS21141S-06-05	Rivet	20 Ea (20 ea)	130-Packaging 1-1 - Pick Kit - B4B	5196061	
MS24665-231	Cotter Pin	1 pcs (1 ea)	130-Packaging 1-1 - Pick Kit - B4B	5113815	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
110-Handfinish - 4 - Assembly	22201BC120090L	1	0	0	
	23111AG120LE	1	40	0	
	AN8C56A	3	18	0	
	ASN52320BH120N	1	9	0	
	D130-1048-041	1	0	0	
	D130-1048-051	1	0	0	
	D5569-3	1	0	0	
	D5570-1	1	4	0	
	D5594-1	6	12	0	
	D5594-3	6	15	0	
	NAS1149C0832R	3	307	0	
	NAS1291C8	3	32	0	
	23111AG100LE	1	4	0	
	ASNA0045BC100L	1	6	0	
130-Packaging 1-1 - Pick Kit - B4B	DHS411-101.3106	1	4	0	
	MS21141S-06-05	20	90	0	
	MS24665-231	1	113	0	
Part Specifications					
Specifications could not be found.					

Plex 6/20/19 1:19 PM Dart.lajeunesse.marie



SHOP COPY
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 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 1816753 M.C.S.
 19-06-20

REV.	DESCRIPTION	BY	DATE
C	REPLACED SKIDTUBE BLADE D5689-3 WAS-1	ZF	19.04.05
B	REDRAWN ADDED VIEWS B-B & C-C ADDED ALTERNATE HARDWARE, ADDED TORQUE AND SEALANT NOTES	ZF	19.02.05
A	NEW ISSUE	ZF	18.05.08

DESIGN	NO	NO	DATE
DRAWN	ZF		
CHECKED	MW		
MFG. APPR.	JFS		
APPROVED	NO		
DE APPR.	CP		
DATE	19.04.05		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO.	D130-1048-011
REV. C	SHEET 1 OF 1
TITLE	SKIDTUBE INSTL. LH (EC130)
SCALE	NTS

RELEASED
 2019 JUN 19 16
 ECN 19-625

APPROVED

1) MATERIAL: N/A
 2) FINISH: NONE
 3) TOLERANCES: N/A
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: N/A
 6) IDENTIFICATION: NONE
 7) WEIGHT: 25.86 lbs
 8) HARDWARE NOT SHOWN, TO BE SHIPPED LOOSE.
 9) TORQUE BOLT TO 15 - 25 in-lbs
 10) TORQUE NUT TO 44 - 62 in-lbs
 11) TORQUE NUT TO 82 - 71 in-lbs
 12) SEAL FAYING SURFACES WITH SIKAFLEX-241/-291
 13) FLUG SEAL WITH SIKAFLEX-241/-291
 14) PLUG SEAL SADDLE HOLES WITH SIKAFLEX-241/-291
 ENSURE SADDLE BORE IS FREE OF SEALANT

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐



Job: _____ Part No. _____		DISPOSITION Rework ☐ ☐ Scrap ☐ ☐ Use-as-is ☐ ☐		DEPARTMENT/PROCESS Skid-tube ☐ ☐ ☐ ☐ Machining ☐ ☐ ☐ ☐ Large Fab ☐ ☐ ☐ ☐ Cross tube ☐ ☐ ☐ ☐ Small Fab ☐ ☐ ☐ ☐ Finishing ☐ ☐ ☐ ☐ Eng. (Non-AW) ☐ ☐ ☐ ☐ Prod. Eng. Coord. ☐ ☐ ☐ ☐ Rec/Store/Packaging ☐ ☐ ☐ ☐ Engineering ☐ ☐ ☐ ☐ Water Jet ☐ ☐ ☐ ☐ Supplier ☐ ☐ ☐ ☐ Quality ☐ ☐ ☐ ☐		MRB (QS1042)																											
Date: _____		Sequence #: _____		QTY Affected: _____																													
Description Work Order Deviation		Disposition																															
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY <table border="1"> <tr> <td>Pressure/Forced</td> <td>Contamination</td> <td>Power Loss/Surge</td> <td>Positioned Wrong</td> </tr> <tr> <td>Bending</td> <td>Misaligned/off center</td> <td>Folio/Program</td> <td>Outside Tolerance</td> </tr> <tr> <td>Crushing</td> <td>BOM/Route</td> <td>Grain Direction</td> <td>Drawing</td> </tr> <tr> <td>Cracks</td> <td>Broken/Damage/Defect</td> <td>Weld</td> <td>Finish</td> </tr> <tr> <td>Crimp/Kink/Ripple/Wave/Twist</td> <td>Incomplete/Unclear Instructions</td> <td>Wrong Stock Pulled</td> <td>Part Lost/Missing</td> </tr> <tr> <td>Marks/Chatter</td> <td>Drill Holes</td> <td>Out of Sequence</td> <td>Misread</td> </tr> <tr> <td>Mislabeled</td> <td>Fit/Function</td> <td>Off-set/Set-up</td> <td></td> </tr> </table> Other/Details: _____				Pressure/Forced	Contamination	Power Loss/Surge	Positioned Wrong	Bending	Misaligned/off center	Folio/Program	Outside Tolerance	Crushing	BOM/Route	Grain Direction	Drawing	Cracks	Broken/Damage/Defect	Weld	Finish	Crimp/Kink/Ripple/Wave/Twist	Incomplete/Unclear Instructions	Wrong Stock Pulled	Part Lost/Missing	Marks/Chatter	Drill Holes	Out of Sequence	Misread	Mislabeled	Fit/Function	Off-set/Set-up	
Pressure/Forced	Contamination	Power Loss/Surge	Positioned Wrong																														
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Crushing	BOM/Route	Grain Direction	Drawing																														
Cracks	Broken/Damage/Defect	Weld	Finish																														
Crimp/Kink/Ripple/Wave/Twist	Incomplete/Unclear Instructions	Wrong Stock Pulled	Part Lost/Missing																														
Marks/Chatter	Drill Holes	Out of Sequence	Misread																														
Mislabeled	Fit/Function	Off-set/Set-up																															
		Completed By		Lead hand / Supervisor																													
		QC / QA Coordinator																															

5.0 PARTS LISTS

5.1 D130-1048-011/-012/-013/-014/-051/-052/-053 Skidtube and Wearplates

QTY -011	QTY -012	QTY -013	QTY -014	QTY -051	QTY -052	QTY -053	P/N	DESCRIPTION
X							D130-1048-011	BASIC SKIDTUBE INSTALLATION, LH
	X						D130-1048-012	BASIC SKIDTUBE INSTALLATION, RH
		X					D130-1048-013	HEAVY DUTY SKIDTUBE INSTALLATION, LH
			X				D130-1048-014	HEAVY DUTY SKIDTUBE INSTALLATION, RH
1		1		X			D130-1048-051 (2)(3)	REPLACEMENT WEARPLATES, LH
	1		1		X		D130-1048-052 (2)(3)	REPLACEMENT WEARPLATES, RH
		1	1			X	D130-1048-053 (3)	MIDTUBE WEARPLATE KIT
		1					D130-1048-041	SKIDTUBE ASSY, LH
	1		1				D130-1048-042	SKIDTUBE ASSY, RH
				1			D5465-1	FWD WEARPLATE, LH
					1		D5465-2	FWD WEARPLATE, RH
				1	1		D5478-1	AFT WEARPLATE
						1	D5613-041	MIDTUBE WEARPLATE
				8	8		AN3C5A	BOLT
				8	8		NAS1149C0332R	WASHER
						2	D5678-1 (4)	NUT
						2	D4012-1	CUSHION
		1	1				D5568-1 (3)	HEAVY DUTY SKIDTUBE BLADE
	1						D5589-3 (2)	SKIDTUBE BLADE
	1	1	1				D5570-1 (2)(3)	BLADE PLUG
	1	1	1				22201BC120090L (1)(2)(3)	BOLT
	1	1	1				23111AG120LE (1)(2)(3)	WASHER (or NAS1149C0832R)
	1	1	1				ASN52320BH120N (1)(2)(3)	NUT
	8	6	6				D5594-1 (2)(3)	GH BUSHING
	6	6	6				D5594-3 (2)(3)	GH WASHER
	3	3	3				AN8C56A (2)(3)	BOLT
	3	3	3				NAS1149C0832R (2)(3)	WASHER
	3	3	3				NAS1251C8 (2)(3)	NUT
1	1	1	1				DHS411-101.3106 (1)	BOLT
	1	1	1				23111AG100LE (1)	WASHER (or NAS1149C0732R)
	1	1	1				ASNA0055BC100L (1)	NUT, CASTELLATED
	1	1	1				EN2367-18028 (1)	COTTER PIN (or MS21665-231)
20	20	20	20				MS21141S0605	MAXIBOLT, BLIND, PAN HEAD (or CR7621S06-05)

- (1) Airbus Helicopter Part Numbers (or alternative) included in kit
 (2) Pre-assembled on D130-1048-011/-012 Skidtube
 (3) Pre-assembled on D130-1048-013/-014 Skidtube
 (4) Pre-assembled on D5613-041 Midtube Wearplate

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Revision: C

Date: 19.02.21

Change Record

PAGE 1 OF 1

Part Number: D130-1048-011

Description: SKIDTUBE INSTALLATION, LH

[illegible]